









Date: Tuesday, 23/09/2008 10:59:49 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2892-1
Job Number : 42245	
Estimate Number : 13233	
P.O. Number :	Part Number : DSK077
This Issue : 23/09/2008 S.O. No. :	Drawing Number : DSK077 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 38203	Material :
Written By :	Due Date : 30/09/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 08.9.23</u>	
Comment : est rev A. 08.03.13 new issue EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	D6104003 Round Billet, 17-4
	
Comment: Qty.: 1 Each(s)/Unit Total: 10 Each(s) Billet Batch: <u>13 42436</u> <u>SA 08/11/02</u> (20)	
2.0	MORI SEIKI MORI SEIKI CNC LATHE LARGE
	
Comment: MORI SEIKI LATHE Turn blank as per Folio FA082 <u>SA 08/11/02</u> (20)	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 08/11/02</u> (20)	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>SA 08/11/03</u> (20)	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Identify and Stock in Kanban Location: <u>CNC</u> <u>SA 08/11/03</u> (20)	
6.0	QC21 FINAL INSPECTION/W/O RELEASE
	
Comment: FINAL INSPECTION/W/O RELEASE <u>08/11/04</u> (20)	
Job Completion 	

MF 08-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42245
Description: Turning Detail for D2892-1		Part Number: DSK077
Inspection Dwg: DSK077	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET



First Article



Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
				2.525				
				Lathe Section				
A	2.524	2.529		2.525	2.525	2.525	2.525	2.525
B	3.702	3.722		3.704	3.706	3.706	3.706	3.706
C	2.814	2.834		2.824	2.824	2.824	2.824	2.824
D	0.718	0.738		.720	.720	.720	.720	.720
E	0.090	0.110		.103	.102	.103	.103	.103
F	2.714	2.734		2.725	2.723	2.723	2.723	2.723
G	2.029	2.049		2.041	2.041	2.041	2.041	2.041
H	3.214	3.234		3.225	3.223	3.223	3.223	3.223
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.103	.103	.103	.103	.103
L								
M								
N								
O								
P								

Measured by: SA 08/11/02	Date:
Audited by: RP 08/11/03	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42245
Description: Turning Detail for D2892-1		Part Number: DSK077
Inspection Dwg: DSK077	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.525	2.525	2.525	2.526	2.526
B	3.702	3.722		3.708	3.708	3.706	3.708	3.708
C	2.814	2.834		2.824	2.824	2.824	2.824	2.824
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.103	.103	.103	.103	.103
F	2.714	2.734		2.725	2.724	2.724	2.725	2.724
G	2.029	2.049		2.041	2.041	2.041	2.041	2.041
H	3.214	3.234		3.225	3.225	3.225	3.225	3.225
I	0.913	0.933		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.102	.102	.102	.102	.102
L								
M								
N								
O								
P								

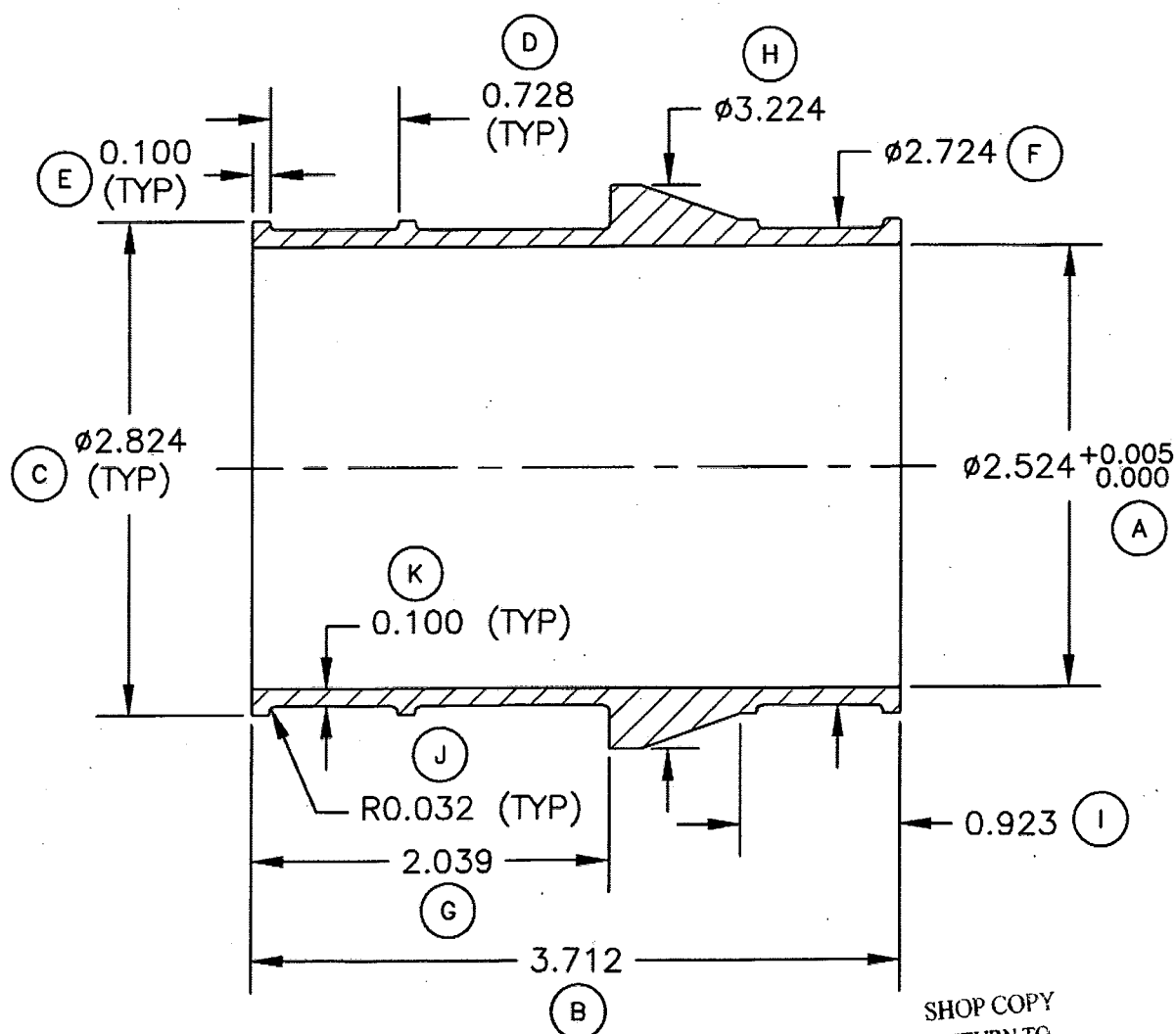
Measured by: SA 08/11/02	Date: 08/11/02
Audited by: 109 08/11/02	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 077	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2892-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]



D2892-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42245

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DART AEROSPACE LTD		Work Order: 42245
Description: Turning Detail for D2892-1		Part Number: DSK077
Inspection Dwg: DSK077	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.525	2.525	2.527	2.524	2.534
B	3.702	3.722		3.708	3.708	3.706	3.707	3.707
C	2.814	2.834		2.827	2.824	2.827	2.824	2.827
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.103	.103	.103	.102	.102
F	2.714	2.734		2.723	2.724	2.727	2.724	2.724
G	2.029	2.049		2.041	2.041	2.041	2.041	2.041
H	3.214	3.234		3.225	3.225	3.225	3.225	3.225
I	0.913	0.933		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.102	.102	.102	.102	.102
L								
M								
N								
O								
P								

Measured by: SA 08/11/02	Date:
Audited by: R4	Date: 08/11/03
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

DART AEROSPACE LTD		Work Order: 42245
Description: Turning Detail for D2892-1		Part Number: DSK077
Inspection Dwg: DSK077	Rev: A	Page 1 of 1

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Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.525	2.525	2.525	2.525	2.525
B	3.702	3.722		3.707	3.707	3.707	3.707	3.707
C	2.814	2.834		2.825	2.825	2.825	2.825	2.825
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.714	2.734		2.727	2.727	2.727	2.727	2.727
G	2.029	2.049		2.041	2.041	2.041	2.041	2.041
H	3.214	3.234		3.225	3.225	3.225	3.225	3.225
I	0.913	0.933		.923	.923	.923	.923	.923
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.102	.102	.102	.102	.102
L								
M								
N								
O								
P								

Measured by: SA 08/11/02	Date:
Audited by: DQ 08/11/03	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	